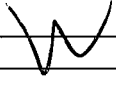
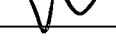



Date: Thursday, 10/04/2008 12:04:24 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D206-667-103A
 Job Number : 38508
 Estimate Number : 10804
 P.O. Number :
 This Issue : 10/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 10/04/2008 Type : CROSSTUBES
 Previous Run : 35515
 Written By : 
 Checked & Approved By : 
 Comment :

Part Number : D206667103A 
 Drawing Number : REWORK-ARM.SHIELD
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 30/04/2008 Qty: 1 Um: Each

Additional Product

Job Number:



DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL 0-09-99			
PN	D206-667-103A	CHG	CHG001
DESC	Crosstube Fwd High	STC	SH01-5
LOT	B33933	STC	SR01304NY
MODEL	Bell 206L/L1/L3/L4	STC	
MADE IN CANADA			


Seq. #: Machine Or Operation: Description:

1.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

RTN FROM OFFSHORE INVENTORY

1 X D206-667-103A B 33933 CHG001 

2.0 D206667103A Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Installation W/ armour shield
 B/N 33933

3.0 SPRAY PAINTING SPRAY PAINTING




Comment: REMOVE SUPPORTS, CLAMPS AND HARWARE

DISCARD HARDWARE IF NO GOOD

KEEP CLAMPS AND SUPPORTS TO REASSEMBLE

STRIP TUBE COMPLETELY TO REMOVE ARMOR SHIELD


 08 04 22 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/04/2008 12:04:24 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-103A

Job Number: 38508

Part Number: D206667103A

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/24 (1)

5.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

> ml 08 04 24 (1)

6.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

ET 08 . 04 - 29

7.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

RE-ASSEMBLE

IDENTIFY ANY NEW PARTS USED:

Abrasion strips B: 35900

1-Install abrasion strips as per QSI 035 using DT8579. Note: (2) Aft holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint.

> ml 08 04 25 (1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/04/28 (1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ENSURE ORIGINAL KIT IN BOX

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: * Thursday, 10/04/2008 12:04:24 PM
User: * Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-667-103A

Job Number: 38508

Part Number: D206667103A

Job Number:



Seq. #:

Machine Or Operation:

Description :

Identify and pack for shipping as per PPP D206-667-103 CHG 001

Location: _____

PPP Rev: _____

Rev B ~~PPP~~

10.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/04/22 @

1808/04/22 @

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/30 @

Job Completion



MF 08-04-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED HDS	APPROVED HDS	DRAWING NO. D206-667-143	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (206L HIGH FWD) NTS	
A	00.11.17	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

UNDER REVIEW

05.07.10 PH

re-draw detail F

Qty	Part Number	Description
X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
1	D6002-115	CROSSTUBE
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2856-400-694	ABRASION STRIP
2	D2891-1	SUPPORT
14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
4	MS21920-20	CLAMP

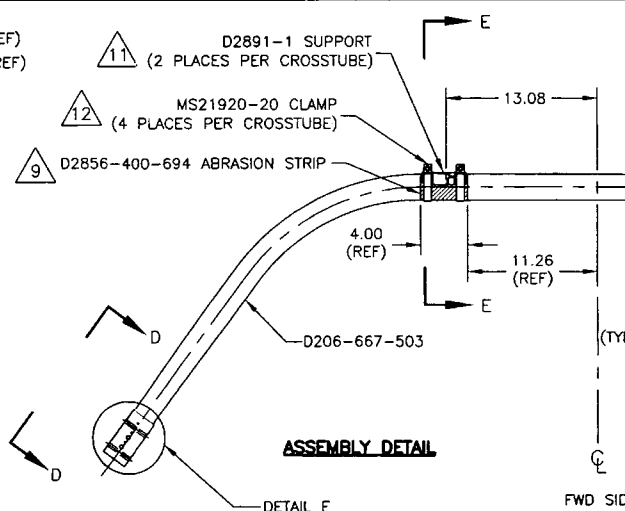
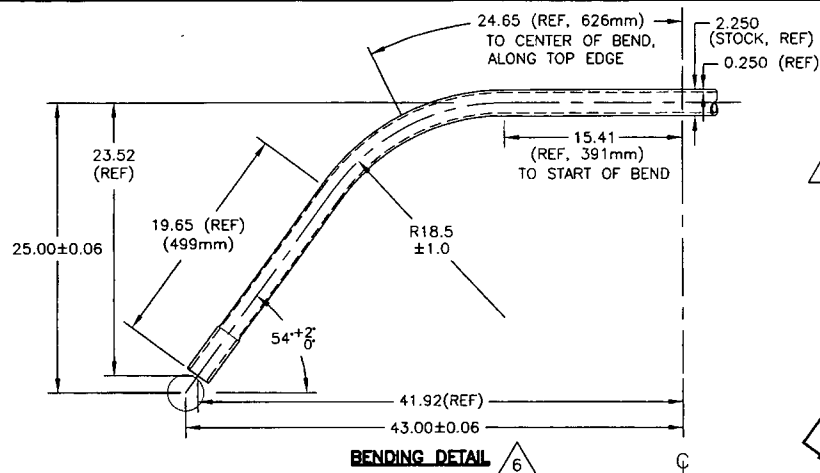
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6002-115
FINISHED LENGTH = 104.98±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

W/10
38568

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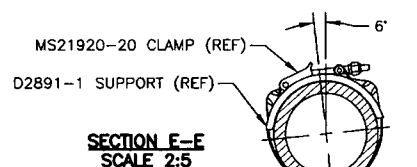


B $\phi 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001
OF HOLE ON OTHER SIDE OF CUFF

PILOT $\phi 0.128$
C'SINK $\phi 0.225 \times 100'$
(TYP 7 PLACES PER CUFF)

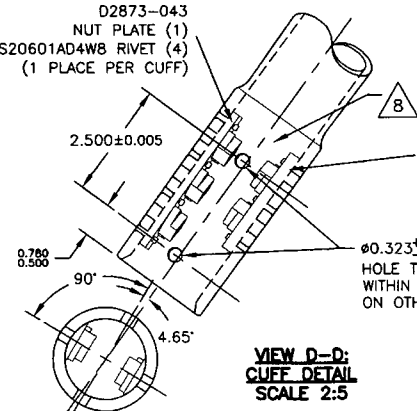
FWD SIDE ONLY

DETAIL F
SCALE 2:5

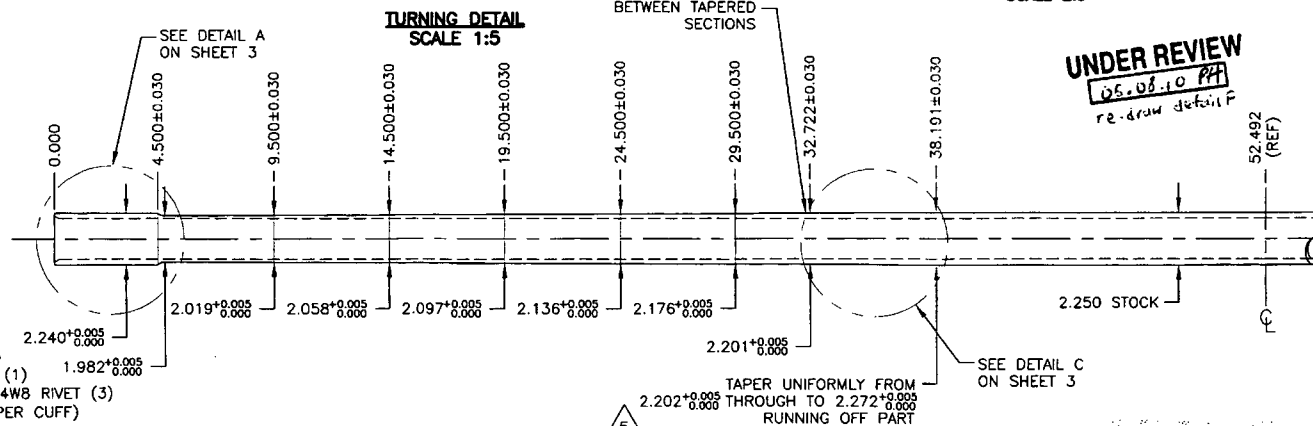


D2856-400-694 ABRASION STRIP (REF)

9
D2873-043
NUT PLATE (1)
MS20601AD4W8 RIVET (4)
(1 PLACE PER CUFF)



$\phi 0.323^{+0.005}_{-0.000}$
HOLE TO BE ALIGNED
WITHIN ± 0.001 OF HOLE
ON OTHER SIDE OF CUFF



R100.0 TRANSITION
BETWEEN TAPERED
SECTIONS
TAPER UNIFORMLY FROM
2.202 ± 0.005 THROUGH TO 2.272 ± 0.005
RUNNING OFF PART

UNDER REVIEW
05.08.10 PH
re-draw detail F

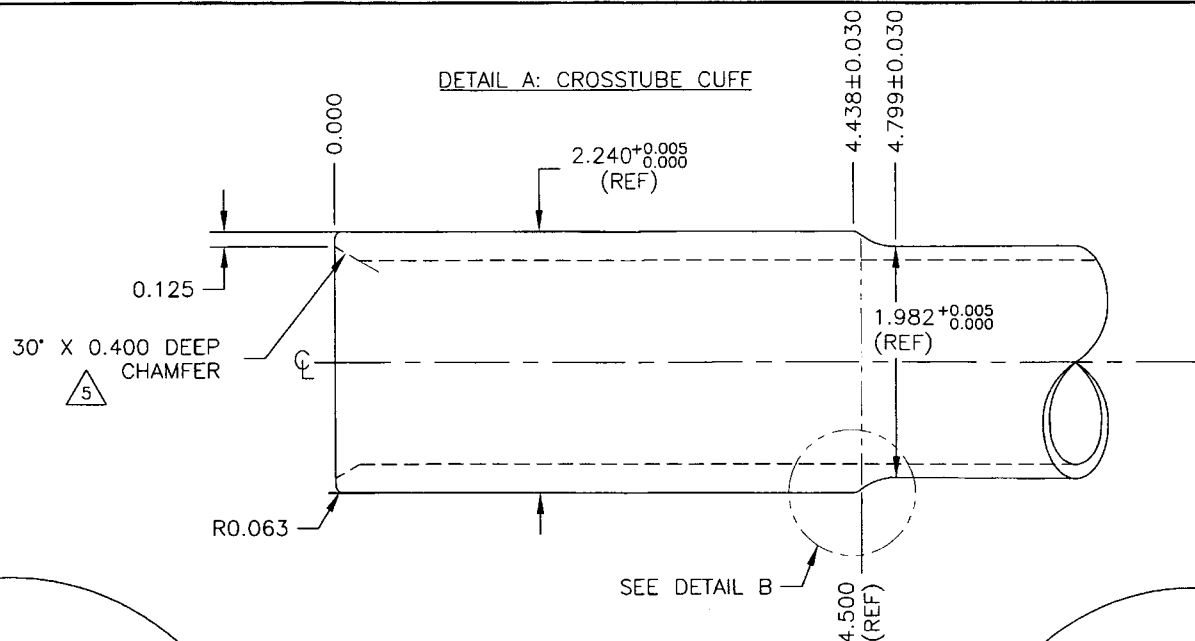
05.07.26

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DESIGN	PH	DRAWN BY	PH
CHECKED	PH	APPROVED	PH
DATE	05.07.26		

DART	DART AEROSPACE LTD. MARRSBOURNE, ONTARIO, CANADA
DRAWING NO. D206-667-143	REV. B SHEET 2 OF 3
TITLE CROSSTUBE ASS'Y (206L HIGH FWD)	SCALE 1:10

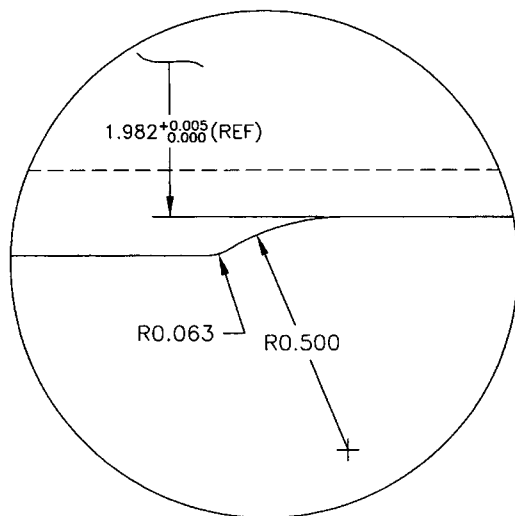


05.07.26 #

UNDER REVIEW

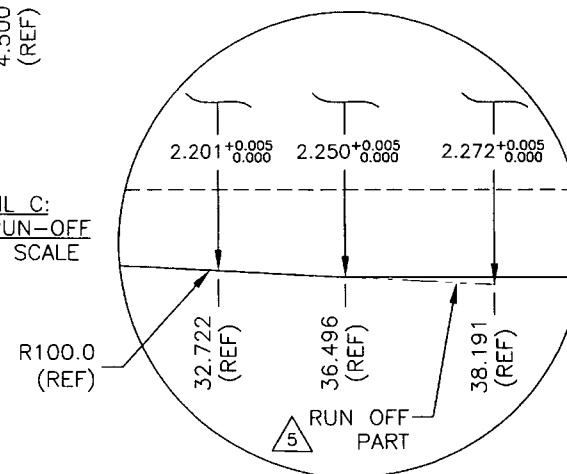
05.07.10 PH

re-draw detail F



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
DATE	05.07.26			D206-667-143	SHEET 3 OF 3
				TITLE	SCALE
				CROSSTUBE ASS'Y (206L HIGH FWD)	1:1

CUSTOMER RETURN

Initiator: S. Williams Date: _____
 Company: Off Shore (E.G.) Location Invoice # _____
 Phone No. _____ Order Entry # _____
 Reason for return: Give to Linda to put back in Dart Inventory Attach Copy of DHS Return Authorization # N/A

Receiving: PC
 Date Received: 4/17 Freight Company: Yellow Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-667-103A	33933	Cross tube		
2	D206-667-203A	33934			

Condition of packaging: Good Photograph required: yes no

Paperwork attached: P/S no Invoice _____ ARC _____ Docs _____ Other _____

QC:
 Quarantine: _____ Location: _____ Condition of Part: _____
 Inspect: _____ Initial: _____

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	

QA Coordinator:
 Advise GM as to findings: _____ Initial: _____ Date: _____

Comments:
Attached copy to custom w/o

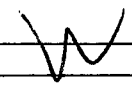
Issue credit: yes no	Invoice Amount: _____
GM Approval: _____	Less Replacement: _____
Date: _____	Restock Fee: _____
	Freight: _____
	Net Credit: _____
	DHS <input type="checkbox"/> Customer <input type="checkbox"/>

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

Date: Thursday, 10/04/2008 12:04:24 PM
 User: Linda Lacelle

Process Sheet

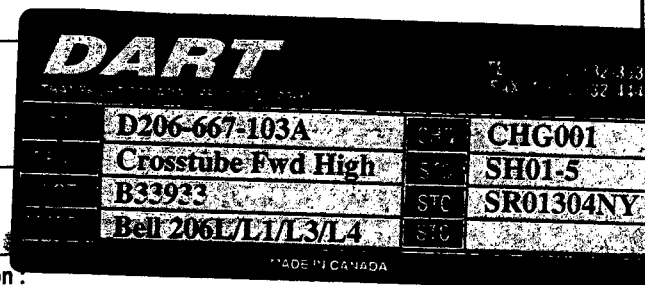
Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 38508
 Estimate Number : 10804
 P.O. Number :
 This Issue : 10/04/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 10/04/2008 Type : CROSSTUBES
 Previous Run : 35515
 Written By : 
 Checked & Approved By :
 Comment :







Drawing Name : D206-667-103A
 Part Number : D206667103A
 Drawing Number : REWORK-ARM.SHIELD
 Project Number :
 Drawing Revision :
 Material :
 Due Date : 30/04/2008 Qty: 1 Um: Each

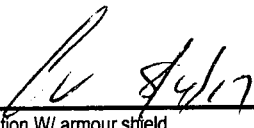
Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	CROSSTUBES	CROSSTUBES RESOURCE 1
		
	Comment: CROSSTUBES RESOURCE 1	
	RTN FROM OFFSHORE INVENTORY 1 X D206-667-103A B 33933	
2.0	D206667103A	Crosstube Installation W/ armour shield
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Crosstube Installation W/ armour shield B/N 33933	
3.0	SPRAY PAINTING	SPRAY PAINTING
		
	Comment: REMOVE SUPPORTS, CLAMPS AND HARWARE	
	DISCARD HARDWARE IF NO GOOD	
	KEEP CLAMPS AND SUPPORTS TO REASSEMBLE	
	STRIP TUBE COMPLETELY TO REMOVE ARMOR SHIELD	


 08 04 22 ①

Red label ✓
 white + PPW
 JLD 08.4.28